



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5162-041
Job Sheet 198611



Part No: D5162-041

Job Qty: 1 pcs

Part Name: Seat Structure Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Due Date: 8/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 18344

Note: DWG D3016 REV (DEO) A1, D5162 REV A, D5189 REV A, D3017 REV C IPP REV:A 14.11.05 NEW ISSUE
DD VERF:JLM IPP REV:B 15-02-06 AS PER DWG REV:A DD VERF:JLMIPP REV:C 16.08.31 ADD D3016
PARTS DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	1 pcs	8/15/19		24.00	4.63	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
140	QC'S	1 pcs	8/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



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CANADA
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Container No: S209626



Part: D5162-041

Job No: 198611

Serial No/Batch: S209626

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/28/19

DAS
81
9-89

AUG 28 2019

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165 Large Fab - Welded Assy-2-B4B	1 pcs	8/15/19	0.00 4.63	Large Fab - 1 - B4B	a
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				QC 9 - 10	
170 QC 9	1 pcs	8/15/19	0.00 0.00	QC 9 - 18	DAS 43 8-89
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
175 QC 5	1 pcs	8/15/19	0.00 0.00	QC 5 - 12	DAS 43 8-89
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Handfinish - 1-1 Chemical-B4B	1 pcs	8/15/19	0.00 0.47	Handfinish - 1 - 1 - B4B	AUG 30 2019
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

7/31/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

190 QC 7	1 pcs	8/15/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	SMB 19/8/30
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
200 Small Fab - 2 - B4B	1 pcs	8/15/19	0.00 1.00	Small Fab - 1 - B4B	SMB 19/8/30
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
210 QC 5	1 pcs	8/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	AUG 3 0 2019 SR
				QC 5 - 61	
				QC 5 - 81	
220 Powdercoat - 3 Grey Sand - B4B	1 pcs	8/15/19	0.00 0.29	Powdercoat - 1 - B4B	
M138839 START 9:15 00:1:30 FINISH 9:45				Powdercoat - 2 - B4B	BE 19-9-5

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230 QC 3	1 pcs	8/15/19	0.00 0.00	Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	smf 19/9/4
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
240 Small Fab - 3 - B4B	1 pcs	8/15/19	0.00 1.00	Small Fab - 1 - B4B	smf 19/9/4
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
250 QC 5	1 pcs	8/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
260 Packaging 3-1 - Stock - B4B	1 pcs	8/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
270 QC 21 - SA	1	8/15/19	0.00 0.00	QC 21 - SA - 21	DAB SEP 04 2019 21 0:00
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (Weld per dwg A/R 4130 rod Batch: M27925) FABRICATE D3017-041 AS PER DWG: USE DT8598 FOR
 Descriptions: BENDING D3017-1/-3 TUBE. USE DT8621 FOR DRILLING (#30 DRILL) BACK FRAME. ***DO NOT OPEN HOLES IT
 WILL BE DONE AT FUTHER STEP*** USE DT8622 FOR DRILLING (#30 DRILL) D3017-5. ***DO NOT OPEN HOLES IT
 WILL BE DONE AT FUTHER STEP*** USE DT8598 JIG FOR WELDING TUBES, LUGS AND ONE END CAP, OTHER
 END CAP WILL BE WELDED AFTER OPENING HOLES.
 140 - (QC5- Inspect part completeness to step on W/O)
 165 - (Weld per dwg A/R 4130 rod Batch: M27925) 1- BOLT SEAT FRAME TO ASSEMBLY PLATE DT8624. 2-
 TRANSFER DRILL D5189-041 TO D3016-041 AS PER DWG USING #30 DRILL AND CLECO THEN DRILL TO FINISH
 SIZE. 3- TRANSFER DRILL SEAT PAN TO D5189-041 AND 3016-041. 4- TRASFER DRILL SEAT AND D3016-041 TO
 D3017-041 USING DT AND USING TOOL TO ACHIEVE DESIRED ANGLE ON BACK REST. ARMREST: 1-
 ASSEMBLE AND TRANSFER DRILL D5189-043 TO D3017-041. OPEN HOLES TO FINISH SIZE AS PER DWG SEAT
 BRACE: 1- USE DT10132 AND DT10133 TO TRANSFER DRILL HOLES IN SEAT PAN AND SEAT BRACE.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 175 - (QC5- Inspect part completeness to step on W/O)
 180 - (Chemical Conversion Coat per QSI005 4.1), CHEMICAL CONVERSION SEAT PANEL D3022-1 AND BACK
 PANEL D3023-1 AS PER DWG
 190 - (QC7-Inspect Chemical Conversion Coat)
 200 - (TO FABRICATE D5162-051) ASSEMBLE D3023-1 PANEL TO D3017-041 BACK FRAME AS PER DWG D5162-
 051
 210 - (QC5- Inspect part completeness to step on W/O)
 220 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), POWDER COAT ALL INDIVIDUAL PARTS START TIME:
 OVEN TEMPERATURE: FINISH TIME:
 230 - (QC3- Inspect Part Finish)
 240 - ASSEMBLE AS PER DWG
 250 - (QC5- Inspect part completeness to step on W/O)
 260 - (Identify as per dwg & Stock Location:)
 270 - (QC21- Final Inspection - Work Order Release)

01737

Job BOM

01/29/18

Part / Item	Component Name	Quantity	Operation	Container
D2199-31	Strut Details	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5152279
D3016-1	Tube	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5203063
D3016-11	Saddle	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5202901
D3016-3	Tube	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5203311
D3016-5	Tube	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5203373
D3016-7	Tube	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5189185
D3016-9	Saddle	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5202709
D5159-041	Seat Back Brace Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5179647
D5159-043	Seat Back Brace Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5179703
D5159-045	Seat Rib Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5209373
M4130NT0.750W.049	4130 Round Tube .750 X.049W	13.8000 ft (13.8 ea)	110-Large Fab - Welded Assy-1	5205920
M4130NT0.750W.083	4130 Round Tube .750 X.083W	2.5000 ft (2.5 ea)	110-Large Fab - Welded Assy-1	5137611
D3016-13	Bracket	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103110
D3016-15	Gusset	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103100
D3016-17	Gusset	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103200
D3017-11	Cap	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5103203
D3017-7	Lug	3 pcs (3 ea)	110-Large Fab - Welded Assy-1	5103092
D3020-1	Fitting	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5152198
D3022-1	Seat Pan	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5202864
D3023-1	Back Panel	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5202880
D4667-041	Armrest Stud Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5162717
D5190-1	Armrest Fitting	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5190326
D5190-3	Weld Pin	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5146053
MS20600-AD4W2	Rivet	40 Ea (40 ea)	200-Small Fab - 2 - B4B	5203371
MS20600-AD4W3	Cherry Rivet	6 Ea (6 ea)	200-Small Fab - 2 - B4B	5203371
ST349 AN3-12A	Bolt	3 Ea (3 ea)	240-Small Fab - 3 - B4B	5146226
ST344 AN4-14A	Bolt	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5183272
ST346 AN4-4A	Bolt	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5148462
ST345 AN4-6A	Bolt	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5156423
ST321 AN970-4	Washer	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5166489-1
ST015 D3024-1	Spacer	3 pcs (3 ea)	240-Small Fab - 3 - B4B	5162557
GA126 D3031-1	Loop	2 pcs (2 ea)	240-Small Fab - 3 - B4B	5162557
CCK004 MS20600-AD4W4	Rivet	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5162557
WA003-6 MS20600-AD4W5	Blind Rivet	8 Ea (8 ea)	240-Small Fab - 3 - B4B	5207585
ST303 MS21042L3	Nut	17 Ea (17 ea)	240-Small Fab - 3 - B4B	FM131618
ST303 MS21042L4	Nut	8 Ea (8 ea)	240-Small Fab - 3 - B4B	5204283
GA014 MS24693-S272	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5192449
ST280 MS27039-1-17	Screw (601.1954)	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5198111
GA017 MS27039-1-18	Screw	3 Ea (3 ea)	240-Small Fab - 3 - B4B	FM127831-4
ST280 MS27039-1-19	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5164326
ST279 MS27039-1-20	Screw	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5156890
ST279 MS27039-4-20	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5182712
ST279 MS27039-4-21	Screw	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5180206
ST264 NAS1149D0332J	Washer	30 Ea (30 ea)	240-Small Fab - 3 - B4B	5185578
ST264 NAS1149D0432J	Washer	17 Ea (17 ea)	240-Small Fab - 3 - B4B	5209100
ST550 NAS43DD4-16FC	Spacer	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5093786
				5156482

5155764

5162557
5205081

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D2199-31	1	6	0
	D3016-1	2	12	0
	D3016-11	2	4	0
	D3016-13	2	10	0
	D3016-15	2	20	0
	D3016-17	2	32	0
	D3016-3	4	8	0
	D3016-5	2	4	0
	D3016-7	4	4	0
	D3016-9	2	4	0
	D3017-11	4	13	0
	D3017-7	3	9	0
	D3020-1	4	8	0
	D3022-1	1	0	0
	D3023-1	1	0	0
	D4667-041	1	18	0
	D5159-041	1	3	0
	D5159-043	1	3	0
	D5159-045	1	1	0
	D5190-1	1	12	0
	D5190-3	1	8	0
	M4130NT0.750W.049	14	93	0
	M4130NT0.750W.083	3	27	0
	MS20600-AD4W2	40	125	0
	MS20600-AD4W3	6	880	0
200-Small Fab - 2 - B4B	AN3-12A	3	204	0
	AN4-14A	2	464	0
240-Small Fab - 3 - B4B	AN4-4A	1	59	0
	AN4-6A	1	423	0
	AN970-4	1	51	0
	D3024-1	3	34	0
	D3031-1	2	6	0
	MS20600-AD4W4	4	1,728	0
	MS20600-AD4W5	8	75	0
	MS21042L3	17	852	0
	MS21042L4	8	2,669	0
	MS24693-S272	4	204	0
	MS27039-1-17	1	34	0
	MS27039-1-18	3	1,119	0
	MS27039-1-19	4	399	0
	MS27039-1-20	2	84	0
	MS27039-4-20	4	78	0
	MS27039-4-21	2	51	0
	NAS1149D0332J	30	2,553	0
	NAS1149D0432J	17	164	0
	NAS43DD4-16FC	2	51	0

Part Specifications

Specifications could not be found.

Plex 7/31/19 9:13 AM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		Date : _____ Sequence #: _____ QTY Affected : _____ MRB (QS1042) _____	
Description Work Order Deviation		Disposition		Completed By			
Root Cause		Fault Category		QC / QA Coordinator			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Other/Details: _____			